Dart Aerospace Ltd.

Date: Friday, 29/09/2006 9:12:38 AM
User: Linda Lacelle

Split-2 06.10.13

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: SADDLE FITTING, FWD (OUTBOARD/INBOARD)
Job Number	: 28779-2		
Estimate Number	: 10531		
P.O. Number	: N/A	**Part Number**	: D2572
This Issue	: 29/09/2006 **S.O. No.** : N/A	**Drawing Number**	: D2572 REV E
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: N/A **Type** : MACHINED PARTS	**Drawing Revision**	: E
Previous Run	: 28445	**Material**	: N/A
Written By	:	**Due Date**	: 06/10/2006 **Qty:** 1 **Um:** Each
Checked & Approved By	:		
Comment	: Est: I 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	D6101005	7075-T7351 8.25X5.0X2.5

Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
7075-T7351 8.25X5.0X2.5
Make from D6101-005 billet for D2572
Ensure that grain is along 5.00" length
Batch No: B25351 J.G 06/09/29

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1

Comment: HAAS CNC VERTICAL MACHINING #1
Program Batch No. 28779 Double check by: J.F.

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
4-Deburr and remove all machining marks
5-Tumble to remove shap edges.

06/10/02

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE

Comment: CONVENTIONAL MILLING MACHINE
Machine keyway as per dwg D2571 & D2572 06/10/02 / 06/10/29

Form: rprocess

Friday, 29/09/2006 9:12:38 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 28779

Part Number: D2572

Job Number:

Seq. #:	Machine Or Operation:	Description :
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	06/10/02 (1)
5.0	QC8	SECOND CHECK
	Comment: SECOND CHECK	J.L 06/10/29
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
	Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1	06/10/31 X 1
7.0	POWDER COATING	POWDER COATING
	Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3	FC 06 11 23 (1)
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
	Comment: INSPECT POWDER COAT	6/11/24 (1)
9.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Identify and Stock Location:_____	6/11/24 (1)
10.0	QC21	FINAL INSPECTION/W/O RELEASE
	Comment: FINAL INSPECTION/W/O RELEASE	06/11/27 (1)

Job Completion

06.11.27

Split
PTO

Form: rprocess

Dart Aerospace Ltd

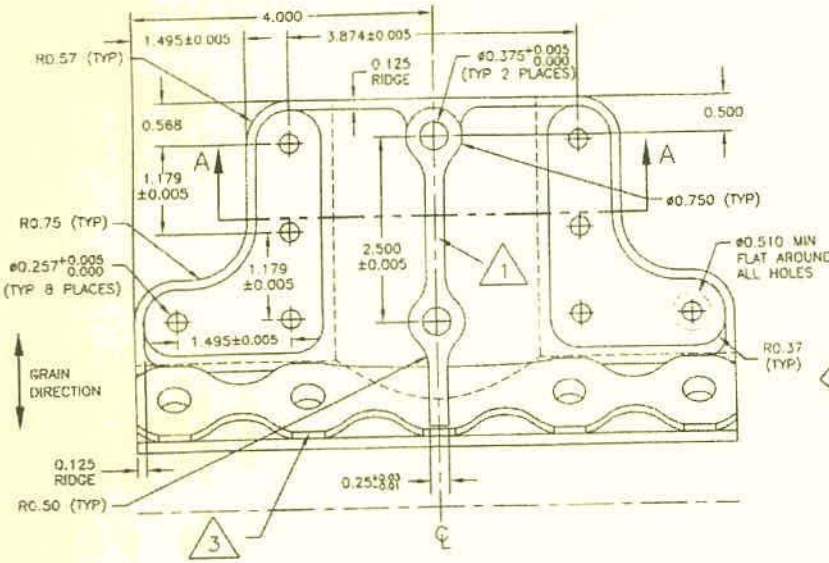
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06.10.13	4.0	wro split for NCR.		06.10.13	1		06.10.13

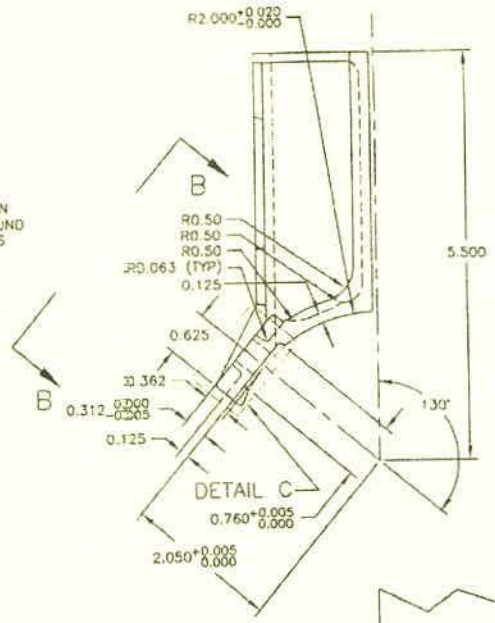
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: _____ Date: 06/11/27

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B: Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
06/10/02	# 2.0	wrong tool was use to machine D.M AD 0.250" was machined to 0.234" (0.016" under nominal) tool was ~~not~~ changed. -only on ~~affected~~ D2572 affected		Acceptable.		06.10.13		06.10.13

NOTE: Date & initial all entries





RELEASED
05.12.06

NOTES

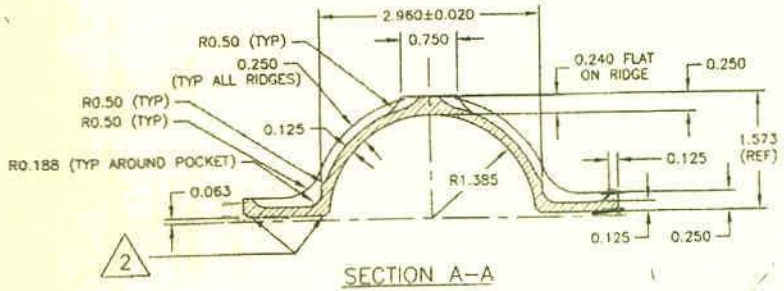
MATERIAL: 7075-T7351 (QQ-A-250/12) (REF DART SPEC. D6102-003)

FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3

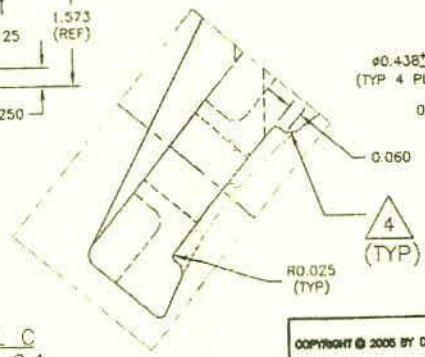
BREAK ALL SHARP EDGES 0.010 TO 0.020

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

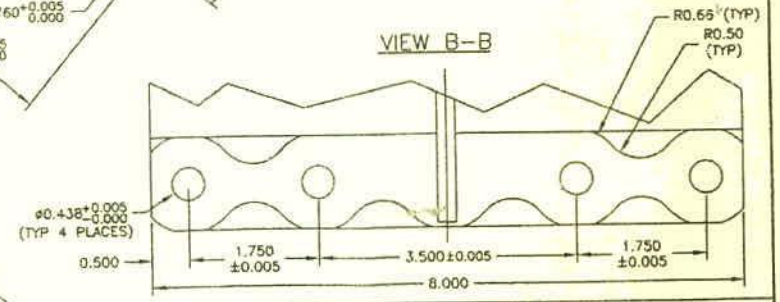
1. ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
2. CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
3. CHAMFER 0.063 x 45° ALL AROUND
4. CHAMFER 0.033 x 45° (SEE DETAIL C) E



SECTION A-A



DETAIL C
SCALE 2:1



E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE

DESIGN: DS	DRAWN BY: PH	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2572 — REV. E — SHEET 1 OF 1
DATE: 05.07.13		TITLE: INNER FWD SADDLE — SCALE 2:3

REFERENCE ONLY

DART AEROSPACE LTD	Work Order:	2979
Description: Saddle, Fwd Inboard	Part Number:	D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	**Min**	**Max**	**Go/No Go Gauge**	**1**	**2**	**3**	**4**	**By**	**Date**
A	0.438	0.443	~~DT9602~~	0.440	0.439	0.439	0.439		
B	1.745	1.755		1.750	1.749	1.750	1.749		
C	3.495	3.505		3.500	3.499	3.500	3.499		
D	1.745	1.755		1.750	1.749	1.750	1.749		
E	7.990	8.010		7.995	7.999	7.999	7.999		
F	0.490	0.510		0.501	0.499	0.501	0.502		
G	0.257	0.262	~~DT9603~~	0.258	0.258	0.258	0.258		
H	0.375	0.380	~~DT9604~~	0.377	0.376	0.376	0.377		
I	0.490	0.510		0.500	0.498	0.500	0.498		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.568	0.568	0.567	0.566		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.494	1.495	1.495	1.495		
N	2.495	2.505		2.499	2.499	2.499	2.499		
O	3.869	3.879		3.873	3.873	3.872	3.873		
P	0.115	0.135		0.124	0.125	0.124	0.124		
Q	0.115	0.135		0.133	0.135	0.135	0.135		
R	0.240	0.260		0.253	0.253	0.253	0.254		
S	0.115	0.135		0.121	0.124	0.125	0.124		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.961	2.960		
V	0.230	0.250		0.241	0.238	0.239	0.241		
W	0.115	0.135		0.116	0.125	0.124	0.124		
X	0.307	0.312		0.309	0.309	0.310	0.308		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.367	0.369	0.365	0.369		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.628	0.628	0.628	0.630		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.245	0.247	0.249	0.252		
AE	1.375	1.395		1.384	1.381	1.382	1.380		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.240	0.240	0.240	0.240		
AH	0.240	0.260		0.252	0.250	0.252	0.253		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.035	0.035	0.035	0.035		
Accept/Reject									

Measured by:	MF	Audited by	EP
Date:	06/10/02	Date:	06/10/13

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order:	28779
Description: Saddle, Fwd Inboard	Part Number:	D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.439	0.439				
B	1.745	1.755		1.749	1.750				
C	3.495	3.505		3.499	3.500				
D	1.745	1.755		1.749	1.750				
E	7.990	8.010		7.999	8.000				
F	0.490	0.510		0.502	0.502				
G	0.257	0.262	DT8683	0.258	0.258				
H	0.375	0.380	DT8684	0.376	0.377				
I	0.490	0.510		0.499	0.506				
J	1.174	1.184		1.179	1.179				
K	0.558	0.578		0.567	0.566				
L	1.174	1.184		1.179	1.179				
M	1.490	1.500		1.500	1.500				
N	2.495	2.505		2.500	2.500				
O	3.869	3.879		3.872	3.872				
P	0.115	0.135		0.124	0.123				
Q	0.115	0.135		0.135	0.135				
R	0.240	0.260		0.253	0.253				
S	0.115	0.135		0.127	0.124				
T	0.178	0.198		0.188	0.188				
U	2.940	2.980		2.966	2.961				
V	0.230	0.250		0.241	0.240				
W	0.115	0.135		0.126	0.124				
X	0.307	0.312		0.310	0.308				
Y	0.760	0.765		0.760	0.766				
Z	0.352	0.372		0.367	0.368				
AA	0.470	0.530		0.500	0.506				
AB	0.615	0.635		0.629	0.629				
AC	0.053	0.073		0.063	0.063				
AD	0.240	0.260		0.251	0.247				
AE	1.375	1.395		1.380	1.381				
AF	0.115	0.135		0.135	0.135				
AG	0.240	0.280		0.241	0.246				
AH	0.240	0.260		0.253	0.253				
AI	2.000	2.020		2.000	2.006				
AJ	0.023	0.043		0.035	0.035				
Accept/Reject									

Measured by:	[illegible] / [illegible]	Audited by	JL
Date:	06/10/02 / 06/10/29	Date:	06/10/29

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	